

Work Order ID 103895

103895

Page 1

Wednesday, July 03, 2013 12:38:46 PM

Item ID: DSK080

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: D2896-1 TURNING DETAIL

Start Date: 7/3/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/19/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: C2

Date: 7/02/103 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK080

Rev A

100

0.00

100

Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

Memo

Turn blank as per Folio FA167

0.00

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

DQA: AA Date: 13-7-9

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: AA Date: 13/9/16Work Order update only ☐

Work Order: <u>103895</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>256 080</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2997</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material	<u>13</u>	<u>100</u>		<u>Blank for sheet (x1)</u>	<u>DAS 16 9-89</u>	<u>Scrap + No replacement</u>	<u>13</u>	<u>13-7-29</u>	<u>DAS 16 9-89</u>
Operator	<u>7</u>	<u>1</u>		<u>Unable to make a part.</u>	<u>Q5304b</u>		<u>7</u>		<u>Q5304b</u>
Offset/Setup	<u>9</u>			<u>Pl. operator error /</u>	<u>13/17/16</u>		<u>9</u>		<u>13/17/16</u>
Process				<u>cut Blank too short</u>		<u>\$287.99</u>			
Supplier				<u>no rework in</u>					
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input checked="" type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Wednesday, July 03, 2013 12:38:46 PM

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Cust Item ID:

Required Date: 7/19/2013 Req'd Qty: 12.00

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Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>CNC</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/9/608

13-09-4

Picklist Print

Wednesday, July 03, 2013 12:38:45 PM

Page 1

Work Order ID: 103895

Parent Item: DSK080

Parent Item Name: D2896-1 TURNING DETAIL

Start Date: 7/3/2013

Required Date: 7/19/2013

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	11.0000	1	12			
17-4 SS Roundbar 6.50"OD													

Location

MAT043

90016

99315

Loc Qty

11

(9)

2

Loc Code

~~11~~ 9

13-2-5

5-45
9-33

no more left

DART AEROSPACE LTD		Work Order:	103895
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.482	3.483	3.483	3.483	3.483
B	3.990	4.010		3.999	3.995	4.000	3.999	3.999
C	3.825	3.845		3.835	3.835	3.835	3.835	3.835
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.097	.097	.097	.097	.097
F	3.705	3.725		3.712	3.712	3.712	3.712	3.712
G	1.360	1.380		1.380	1.380	1.380	1.380	1.380
H	1.250	1.260		1.256	1.256	1.256	1.256	1.256
I	6.490	6.510		6.498	6.495	6.499	6.500	6.500
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127		.114	.113	.113	.114	.113
M								
N								
O								
P								

Measured by:	<i>[Signature]</i>	Date:	13-7-5
Audited by:	<i>[Signature]</i>	Date:	13-09-04
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	103895
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

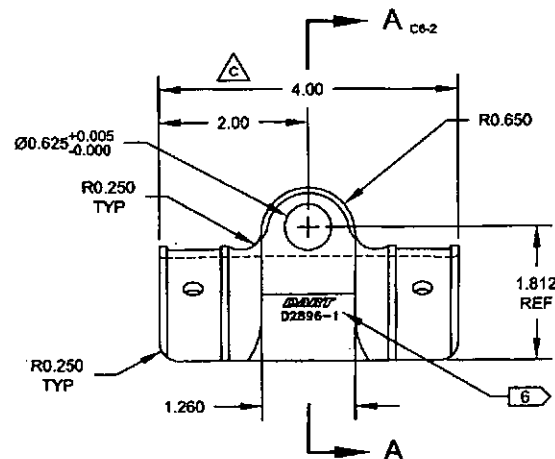
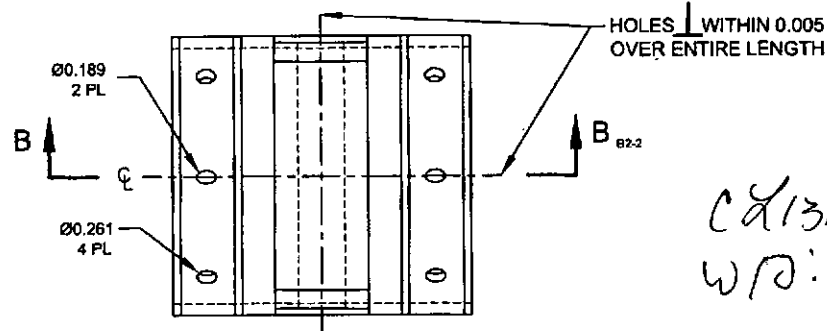
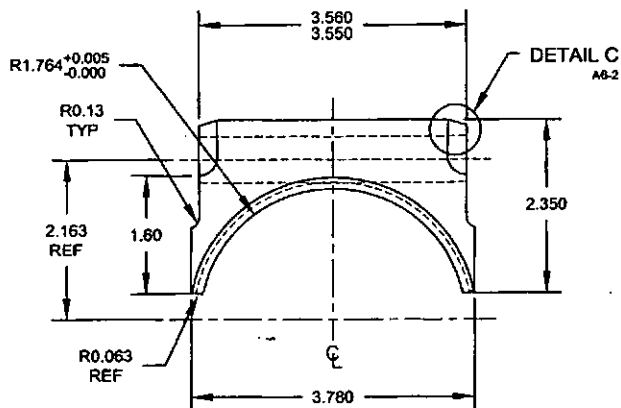
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.483	3.489	3.483		
B	3.990	4.010		4.000	3.999	3.999		
C	3.825	3.845		3.835	3.835	3.835		
D	0.718	0.738		.728	.728	.728		
E	0.090	0.110		.099	.099	.099		
F	3.705	3.725		3.712	3.712	3.712		
G	1.360	1.380		1.380	1.380	1.380		
H	1.250	1.260		1.256	1.256	1.256		
I	6.490	6.510		6.500	6.498	6.498		
J	0.022	0.042		.032	.032	.032		
K	0.240	0.260		.250	.250	.250		
L	0.107	0.127		.113	.113	.114		
M								
N								
O								
P								

Measured by: 9.08 / JA Date: 3.7.8

Audited by: JA Date: 13-09-04

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>JA</u>

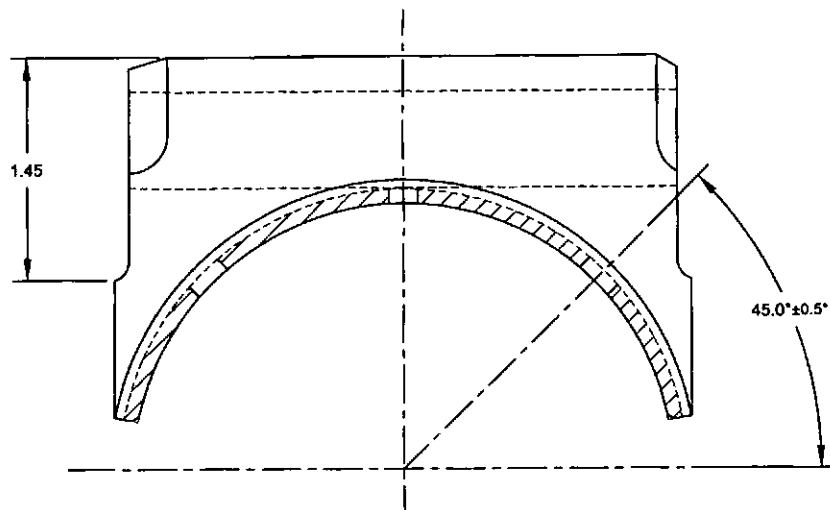


D2896-1 SUPPORT

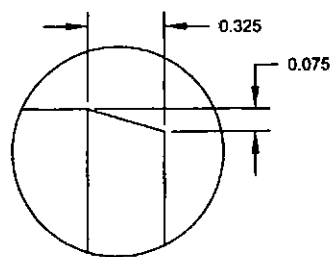
NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION PER ASTM A564 OR AMS 5643 OR AISI 630 MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

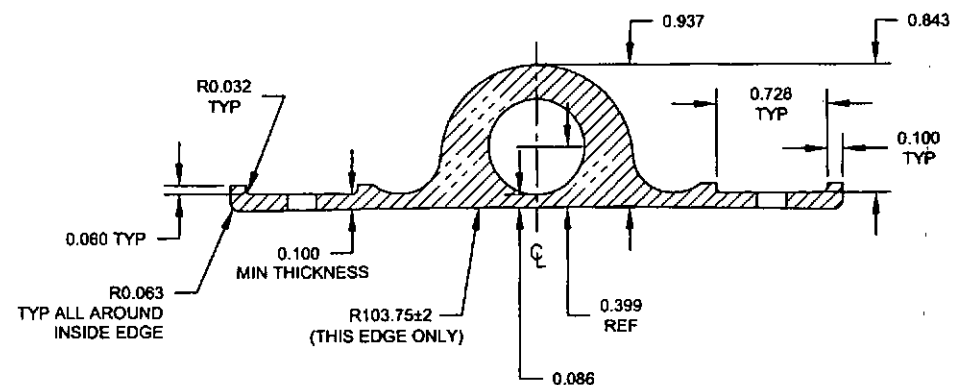
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B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
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SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



DETAIL C C6-1
SCALE 4X



SECTION B-B D3-1
SCALE 2X

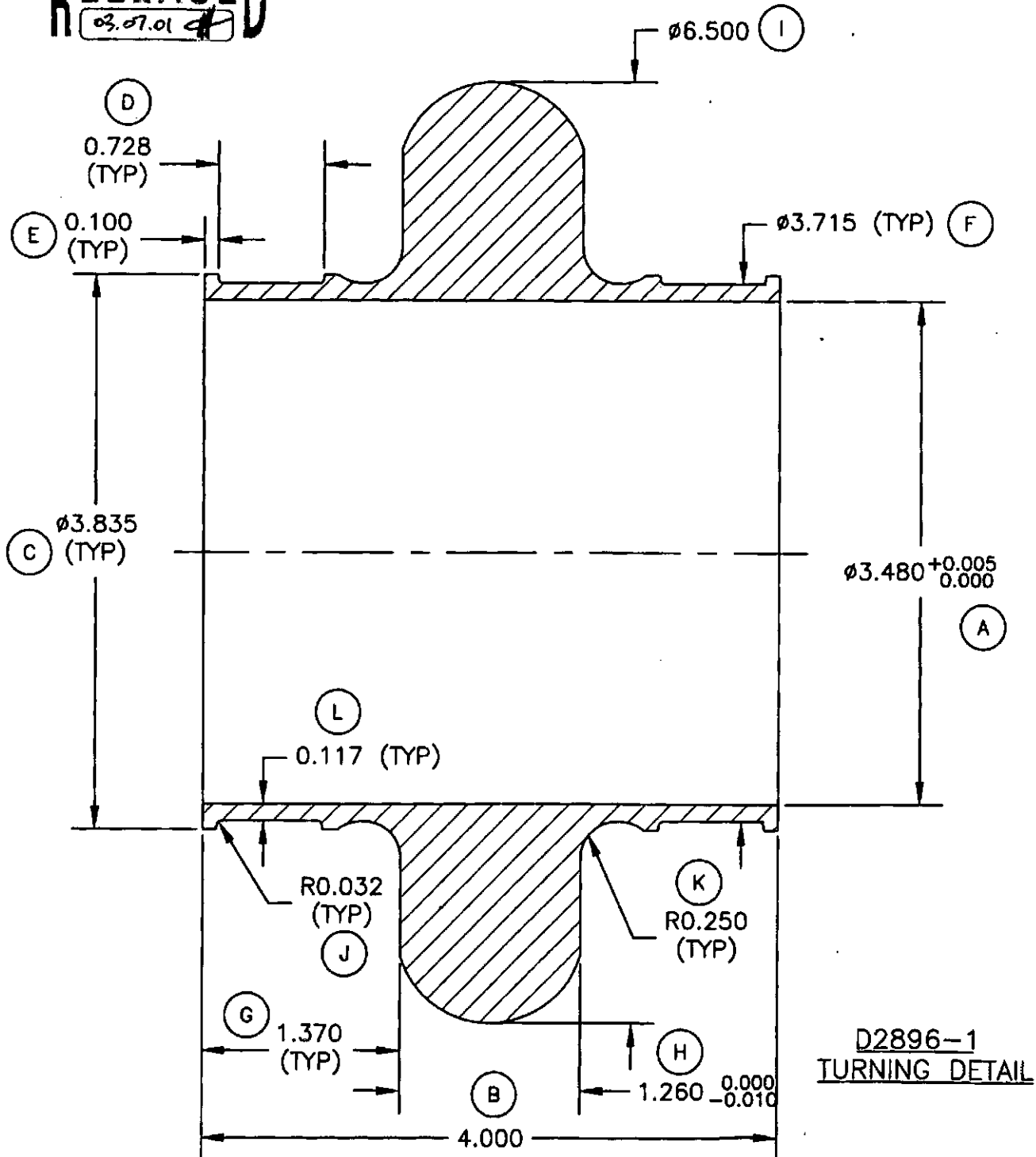
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2011-09-29

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20	TITLE TURNING DETAIL FOR D2896-1		SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]



D2896-1
TURNING DETAIL

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